

Work Order ID 77007 - 2

77007

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Thursday, November 24, 2011 3:20:06 PM

Item ID: D4154-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly

Start Date: 11/24/2011 Start Qty: 6.00 *6*
 Required Date: 12/5/2011 Req'd Qty: 6.00 *6*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: Date: 11-11-24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4154	B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH#: M118367

2059B → 120028

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH#: M118367

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

(x2)

MAL

12/03/08

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

RPL 12-03-08

2X

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00		5/21/09		(2)			
Quality Control									
150		0.00							
150									
Small Fab	Memo	0.00				A	12-3-8	(2)	
Small Fab	1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154.								
	B120579								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00		5/21/09		(2)			
Quality Control									



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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>FP-I</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

2X m-12/03/09

MLC 12/03/09

12-03-9

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, November 24, 2011 3:20:11 PM

Work Order ID: 77007

77007

Parent Item: D4154-041

D4154-041

Parent Item Name: Wearplate Assembly

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
 10.11.04 added DT9684 DD verf:EC
 per dwg revB DD verf:EC
 IPP Rev:B
 IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1		Manufactured	No			100	Each	7.0000	1	6			
D4154-1									**	(x2)		MAL	12/03/08
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
					66312			1					
					74075			6					
D4155-1		Manufactured	No			100	Each	6.0000	1	6			
D4155-1									**	(x2)		MAL	12/03/08
Bar													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					74076			6					

W/O:		WORK ORDER CHANGES					
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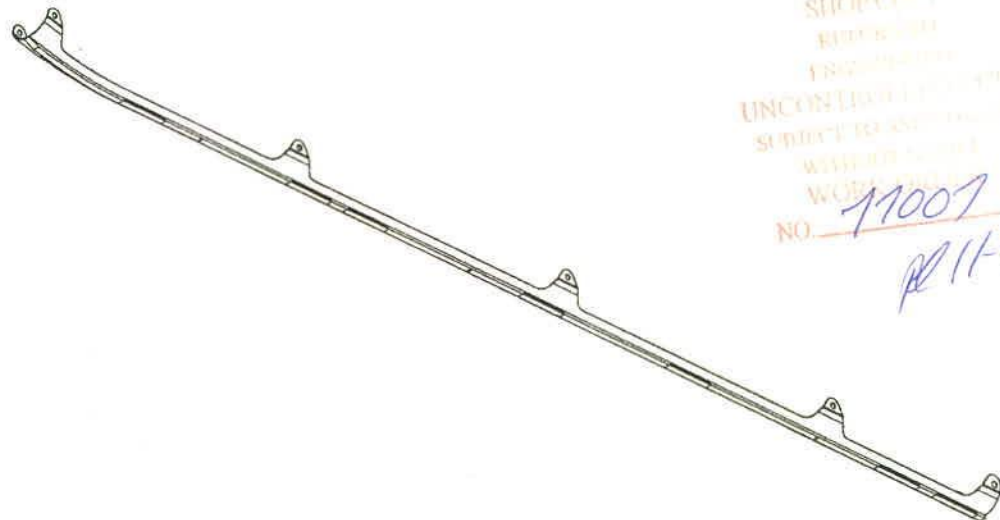
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2050B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

△B

SHOP COPY
 REVISION
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITHIN 30 DAYS
 WORK ORDER NO. 11007
11-11-24



D4154-041 WEARPLATE ASSEMBLY

RELEASED
 R 2011-04-11

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A3-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4154 REV. B SHEET 1 OF 3 TITLE WEARPLATE ASSEMBLY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF THE INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
DE APPR.	SC		
DATE	11.04.05		

8 7 6 5 4 3 2 1

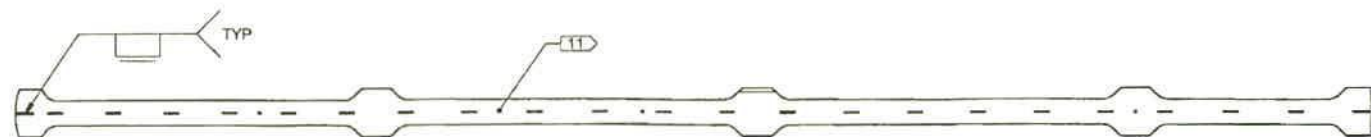
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D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	5	DRAWING NO.	REV. B
MFG. APPR.	5	D4154	SHEET 2 OF 3
APPROVED	11/04/05	TITLE	SCALE
DE APPR.	11/04/05	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

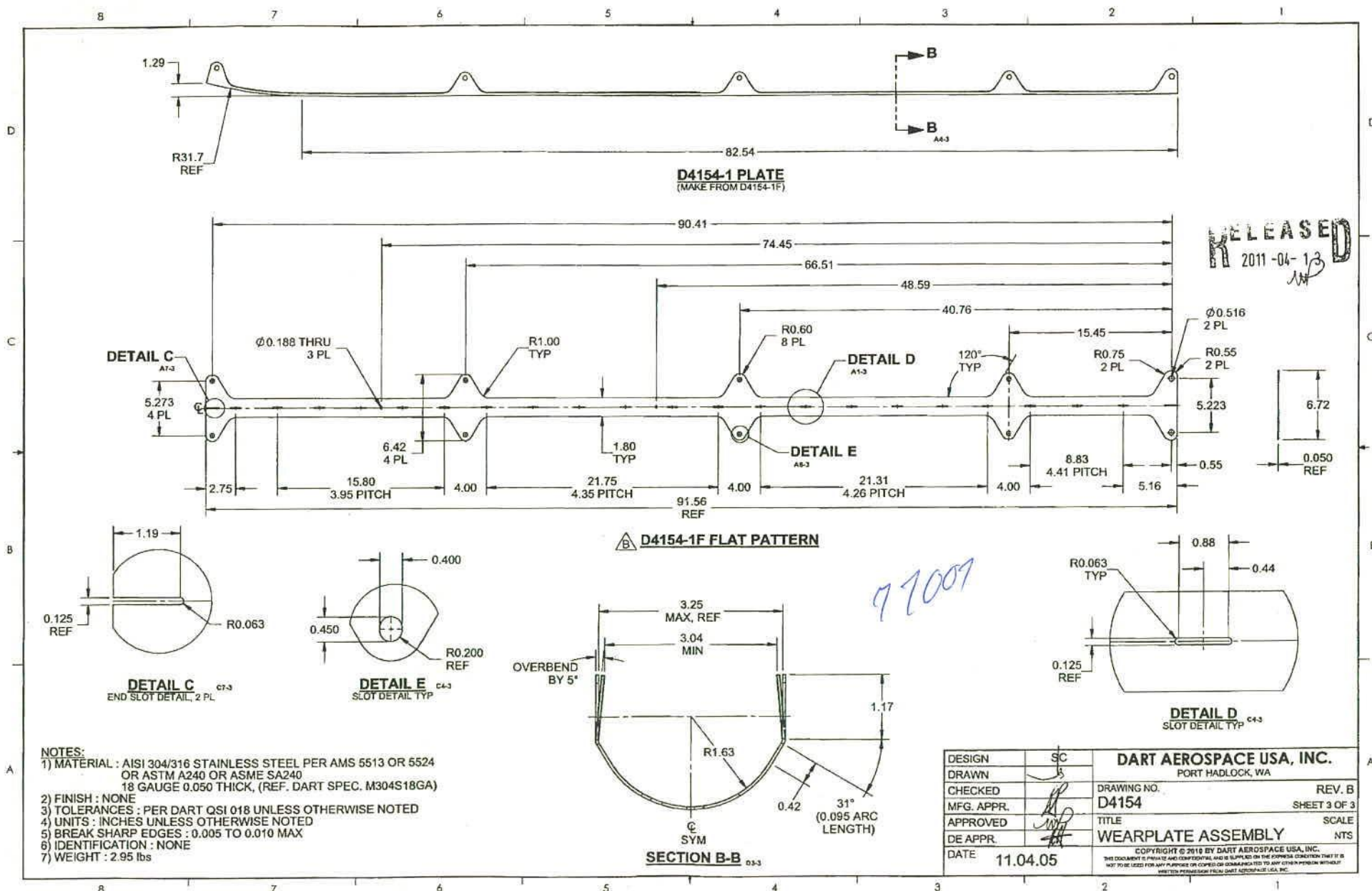
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